

Date: Friday, 30/01/2009 7:50:12 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GHW LUG
Job Number	: 45372		
Estimate Number	: 11217		
P.O. Number	:	Part Number	: D34041
This Issue	: 30/01/2009 S.O. No. :	Drawing Number	: D3404 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11	Drawing Revision	: C
Previous Run	: 43141	Material	:
Written By	: <u>ML 09-01-30</u>	Due Date	: 06/02/2009
Checked & Approved By	:	Qty:	<u>60</u> Um: Each
Comment	: Est Rev:A 05.09.01 New issue KJ/JLM Est rev B 09.01.28 new geometry rev.C EC verified by:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B0750X2500	304 BAR .750 X 2.50
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Comment: Qty.: 0.2406 f(s)/Unit Total: 48.1110 f(s)

NO MORE MATL

Material: AISI 304/316 SS Bar 2.50" x 0.75" thick

(M304B0.750x02.500)

M101933X7

Identify for D3404-1

Batch: M105802 X109

ML 09/01/31

Set for 116 only made 60 CL

(116)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank: 2.750" long

ML 09/01/31

(116)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA555 and Dwg D3404

Dwg Rev: C Folio Rev: C

2-Deburr

88 09/02/03

H.A 09/01/31

(60)

(116)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 09/01/31 / 88/02/03

(60)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ML 09/02/05

(60)

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Part Number: D34041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BRIC/S-21A

Rec'd 6/2/09 (60)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/09

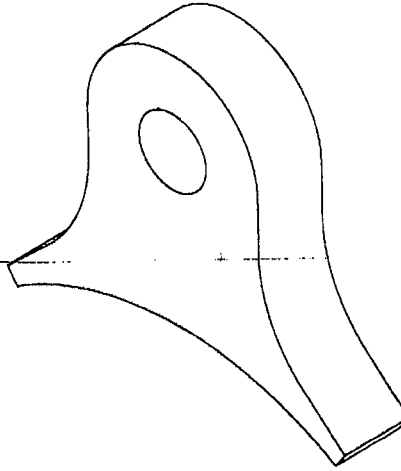
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CL09102104

w/o 45372



D3404-1 GHW LUG

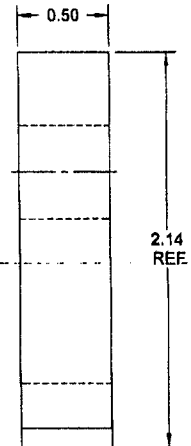
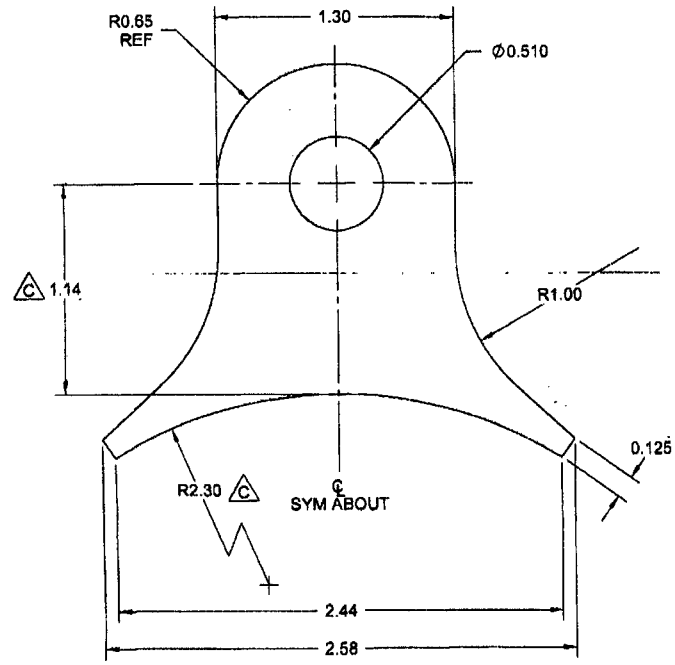
RELEASED
08/12/18 NW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.		AJS	08.12.02
B	UPDATE M-SPEC		PH	05.08.14
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		D3404	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG	NTS	
DATE	08.12.02	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

u/o 45372



RELEASED
08/12/02

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3404	REV. C
MFG. APPR.		TITLE GHW LUG	SHEET 2 OF 2
APPROVED		SCALE NTS	
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.12.02		